Work Order ID	59004
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Friday, May 21, 2010 8:53:28 AM



Page 1

Item ID:

D205-634-041

Accept

Setup Start

Stop

Revision ID:

Item Name:

Replacement Skidtube

5/21/2010 Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Start Date:

Approvals: Process Pl

Required Date: 5/31/2010

Process Plan: ______QC:

Date: 10-5-2 / Tooling:

Date: _____ SPC (Y/N):

_____ Date:______

Date:

Run Start

Sequence ID/ Work Center ID

Operation Description

Set Up/ Run Hours Draw Number Draw Rev. Plan Accept Code Qty Reject Qty

Reject Insp. Number Stamp

Draw Nbr

Revision Nbr

D2580 Rev D

100

DOCUMENT CONTROL

Memo

0.00

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A HS

110

CNC Bend I

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.00

0.00

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

10-5

- all livioopace Ela	Dart	Aero	space	Ltd
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W/O:			WC	RK ORDER CHANG	GES					*
DATE	STEP	PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod-Mgr	Approval QC Inspector
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<u> </u>										
Part No		PAR #:								
	R	esolution:	Disposition	1:	QA: N	I/C Clo	sed:		Date:	
NCR:	,		WORK ORDE	R NON-CONFORM	ANCE (NCR)				
DATE STEP		Description of NC	Corrective Action		tion B		Verification		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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'Work Order ID 59004

Friday, May 21, 2010 8:53:28 AM



Page 2

Item ID:

D205-634-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

5/21/2010

Start Qty: 1.00

Required Date: 5/31/2010

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:	Process	Plan
	QC:	

Date:

Date:

Tooling:

Date:

Draw

Run

Start

Stop



Sequence ID/ Work Center ID

120



Skidtubes

Operation **Description**

Set Up/ **Run Hours**

Memo 1- Deburr ends

QC5- Inspect part completeness to step on W/O

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

Memo

0.00

0.00

1 8 DE 19/06/01

Quality Control

SPC (Y/N):

Date:

Plan Draw ' Number Rev.

Code Qty

Accept

Reject Qty

Reject Insp. Number

Stamp (W M) 10-5-31

Dart A	erospac	e Ltd
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W/O:			W	ORK ORDER CHANGI	ES			
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA: _	Date: _	
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NCR:		V	VORK ORE	ER NON-CONFORMA	NCE (NCR			
DATE	STEP	Description of NC			Verification ∆nı			
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Work Order ID 59004

Friday, May 21, 2010 8:53:28 AM



Page 3

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

5/21/2010

Start Qty: 1.00

Required Date: 5/31/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Da	ate:		R	tun Sta	rt	
	QC:	Date:	SPC (Y/N):	Date:			Sto	P		
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			0.00							

Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R□□□ Aluminum Rod

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill A/R□□□ Aluminum Rod

MILLOOU

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

adjust stopper not to hit web Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

M10101/02

Dart Aerospace	Ltd
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W/O:			V	VORK ORDER CHANG	ES			τ. •
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Work Order ID 59004

Friday, May 21, 2010 8:53:28 AM



Page 4

Item ID:

D205-634-041

Accept



Setup Start

Stop

Revision ID:

Item Name:

Replacement Skidtube

Start Date:

5/21/2010

Start Qty: 1.00

Required Date: 5/31/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Draw

Reference:

An	provals:
4 2 12	provais.

Process Plan:

Date:

Date:_____

Tooling:

SPC (Y/N):

Date:

Run

Stop

Start



Sequence ID/ **Work Center ID**

150

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Set Up/ **Run Hours**

Number

Date:

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp. Stamp Number

Memo

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

170

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd

cap out of solution.

10 06

W/O:			٧	VORK ORDER CHA	ANGES					τ
DATE	STEP	PR	OCEDURE CI	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		solution:								
NCR:		,	WORK OR	DER NON-CONFO	RMANCE	(NCR)			
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Work Order ID 59004

Friday, May 21, 2010 8:53:28 AM



Page 5

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

5/21/2010 **Start Date:** Required Date: 5/31/2010

Start Qty: 1.00 Req'd Qty: 1.00

Cust Item ID: Customer:

Reference:

A	ppr	oval	s:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

180

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/ **Run Hours**

0.00

Draw Number

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

START TIME: **OVEN TEMPERATURE** FINISH TIME:

0.00

D bl 10.616

190

QC

QC3- Inspect Part Finish

Memo

0.00

10/06/16

Quality Control

W/O:				VORK ORDER CHANG	ìES				•
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NCR:				DER NON-CONFORM					
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Revision ID:	D205-634-0			Accept					Setup	Start		
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Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		te:			Run	Start Stop	* ********	
Sequence ID/ Work Center ID 200		Operation Description		Set Up/ Run Hours 0.00	Draw Number	Draw Rev.	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
HandFinish Hand Finishing		Sikaflex on i A/R □□□ Sikaflex exp 2-Coat D259 per Dwg D2: 3-Inspect for 4-Install 285 Sikaflex. Cl A/R □□□ Sikaflex exp	insert holes before installing Sikaflex-291	13 ST9 \\ um Jelly and install on D2 24 2580 and seal Fwd Step & 11 3 F \\	2594-1 plugs as		10/06	(16				

W/O:		WORK ORDER CHANGES										
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Work Order ID 59004

Friday, May 21, 2010 8:53:28 AM



Page 7

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

5/21/2010

Start Qty: 1.00

Required Date: 5/31/2010

Req'd Qty: 1.00



Date:_____

Cust Item ID:

Customer:

Reference:

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Process Plan:

Date:

Tooling: SPC (Y/N): Date:

Date:

Start

Run

Stop



Sequence ID/

Operation **Work Center ID** Description

QC:

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

Draw Number Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

210

Quality Control

Memo

0.00

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for

Foreign objects per QSI 024

220

Packaging

Packaging

Memo

0.00

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041 Location:

230

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/17 75) MF 10-6-17

/v 10/4/6 (V)

W/O:		WORK ORDER CHANGES											
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Picklist Print									Page 1
Friday, May 21, 2010	8:53:33 A	IM							1 450 1
	04 5-634-041 Replacement	. Ol.: de.l.		I (1811) 881) 1811) 8181 1881 8 1881 8881 8					5
Comments: I	PP Rev:N□		EC verwork	EC	ĵ		Start Date: 5 Start Qty: 1		Required Date: 5/31/2010 Required Qty: 1.00
D2580-1 205 Skidtube bent detail		Manufactured	No		110	Each	8.0000 1	1	
D2576-3		Manufactured	No	Location LG 57028 58112 58384 58385 58618 58619	<u>Loc (</u>	8 1 1 1 2 2 Each	101.0000 I	1	5-5-31
Step (maching detail) D2579 Crossbolt Spacer		Manufactured	No	Location LG 46661 52215	<u>Loc (</u>	Oty 101 53 48 Each	13.0000 20	20	DE 10/06/02
Ciossoon Space				Location LG 57052 57348	Loc (13 5 8	Loc Code		BE idolelo 2

DE 1906/02

Dart Aerospace L	_td
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W/O:		WORK ORDER CHANGES										
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Friday, May 21, 2010 8:53:33 AM

Shop Packet Print

Page 2

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Picklist Print

Friday, May 21, 2010 8:53:33 AM

Page 3

Work Order ID: 59004

D205-634-041



JLM

Start Date: 5/21/2010

Required Date: 5/31/2010

41/20/16

Start Qty: 1.00

Required Qty: 1.00

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork EC

Purchased

IPP Rev:P 07-07-09

SS Wearplates & Gaskets No

200

Each

Loc Qty

1289

501

1,289.000

Loc Code

12114859

50

50

AN3C4A

BOLT

Location ST350

114103 114108 114416 114523

300 12 476 200 Each

0.0000

50

V50

AN960C10L

NAS1149C0332

Purchased

No

M1)1341

50

washer

D3566-13

Manufactured No 200

Each

28.0000

Gasket

Gasket

D3566-5

Manufactured No

(53461)

Loc Qty 28 28 200 Each

16.0000

Loc Code

10/06/16

Location FP015

Location

FP

57682

Loc Qty 16

16

Loc Code

10/06/16

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DATE	STEP	PRO	CEDURE CH	IANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Friday, May 21, 2010 8:53:33 AM Work Order ID: 59004 Parent Item: D205-634-041 Parent Item Name: Replacement Skidtube Start Date: 5/21/2010 Required Date: 5/31/2010 IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ Comments: Start Qty: 1.00 Required Qty: 1.00 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork SS Wearplates & Gaskets IPP Rev:P 07-07-09 JLM D3566-1 Manufactured No 200 Each 31.0000 2 2 Gasket Location Loc Oty Loc Code FP015 31 57715 10 51120/cm 1x xx 21 D3564-11 Manufactured No 200 Each 4.0000 Wearshoe Location Loc Otv Loc Code 41 10104112 359021 FP019 57957 4 D3564-13 Manufactured No 200 Each 22.0000 Wearshoe Location Loc Qty Loc Code FP17 22 57684 8 10/06/16 **(**57922) 14 D3564-9 Manufactured No 200 Each 17.0000 Wearshoe

Location Loc Qty Loc Code FP 55334 1

FP019

(57958

14

16 2

10/04/14

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Friday, May 21, 2010 8:53:33 AM

Work Order ID: 59004

D205-634-041



Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09

SS Wearplates & Gaskets

Start Date: 5/21/2010

Required Date: 5/31/2010

Start Oty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

24.0000

Loc Code

Wearshoe

Manufactured

Manufactured

No

34806

Location

FG

FP19

JLM

57525

200

200

1 22 Each

23

Loc Qty

327.0000

16

10/00/16

16

D2594-3

O-Ring, 205 Skidtube

Location FP

(58191)

Loc Qty Loc Code 327 19 308 Each 518.0000

16

X16 20 10106/16 16

D2594-1

Plug, 205 Skidtube

Location Loc Qty Loc Code FP 334 1359110 42807 112 55002 80 57826 142 FP14 184 58434 184

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W/O:			WORK ORDER CHANGES									
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR))					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	cription Sign &			ation on C	Approval Chief Eng	Approval QC Inspector		
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DESIG	H	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED //	APPROVED	DRAWING NO. REV. D
			D2580 SHEET 1 OF 3
DATE			TITLE SCALE
07.0	02.27		205 SKIDTUBE ASSEMBLY NTS
Α		96.09.16	NEW ISSUE
В		96.12.02	AS MANUFACTURED
С		98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D		07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

BS105-21



QTY -041	QTY -045	Part Number	Description	
Х		D2580-041	SKIDTUBE ASSEMBLY	
	Х	D2580-045	SKIDTUBE ASSEMBLY	
1		00500 4 400		SHOP COPY
1	1	D2500-1-190	EXTRUSION	
	1	D2576-3	STEP	RETURN TO
20	24	D2579	CROSS BOLT SPACER	ENGINEERING
16	16	D2594-1	PLUG	LINCONTROLLED COPY
16	16	D2594-3	O-RING	SUBJECT TO AMENDMENT
1	1	D2596	205 WEB	WITHOUT NOTICE
1	11	D2855	AFT CAP	
1	1	D3564-5	WEARSHOE	WORK ORDER
1	1	D3564-9	WEARSHOE	N) <u>59009</u>
1	1	D3564-11	WEARSHOE	
1	1	D3564-13	WEARSHOE	BS105-2
2	2	D3566-1	GASKET	
_ 1	1	D3566-5	GASKET	
11	1	D3566-13	GASKET	
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT	
50	50	AN3C4A	BOLT	
2	2	AN3-5A	BOLT	
50	50	AN960C10L	WASHER	
2	2	AN960JD10L	WASHER	

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- **ALL DIMENSIONS ARE IN INCHES**
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL \varnothing 0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:

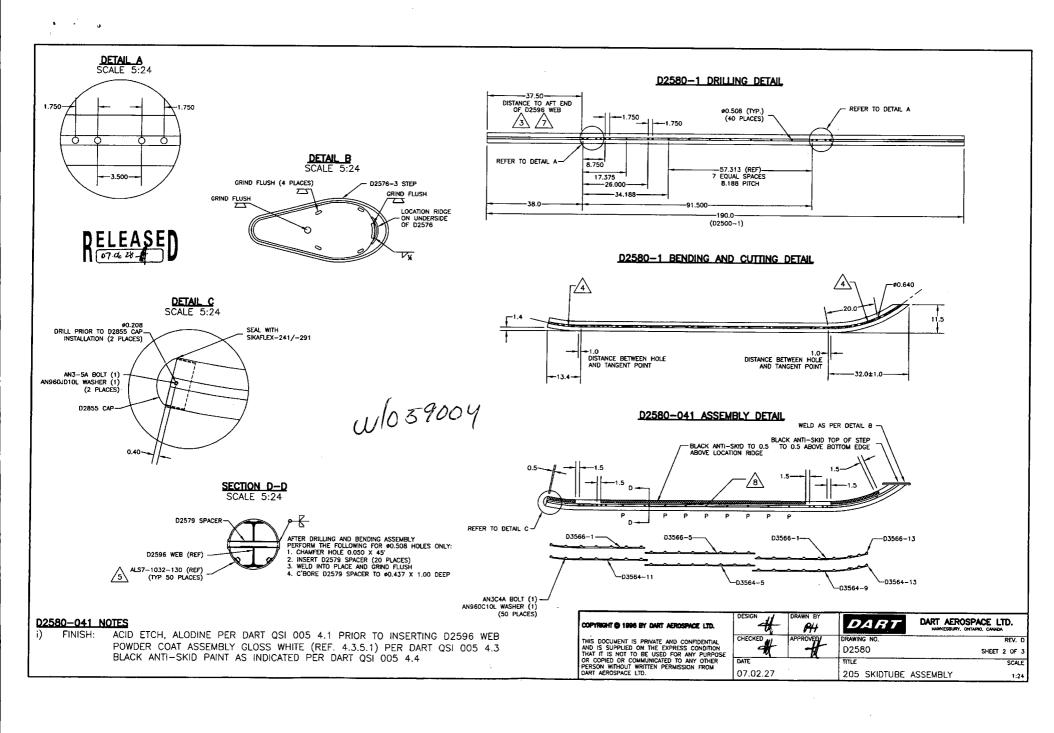
SEE NOTES ON

PAGE 2 FOR D2580-041 AND PAGE 3 FOR D2580-045

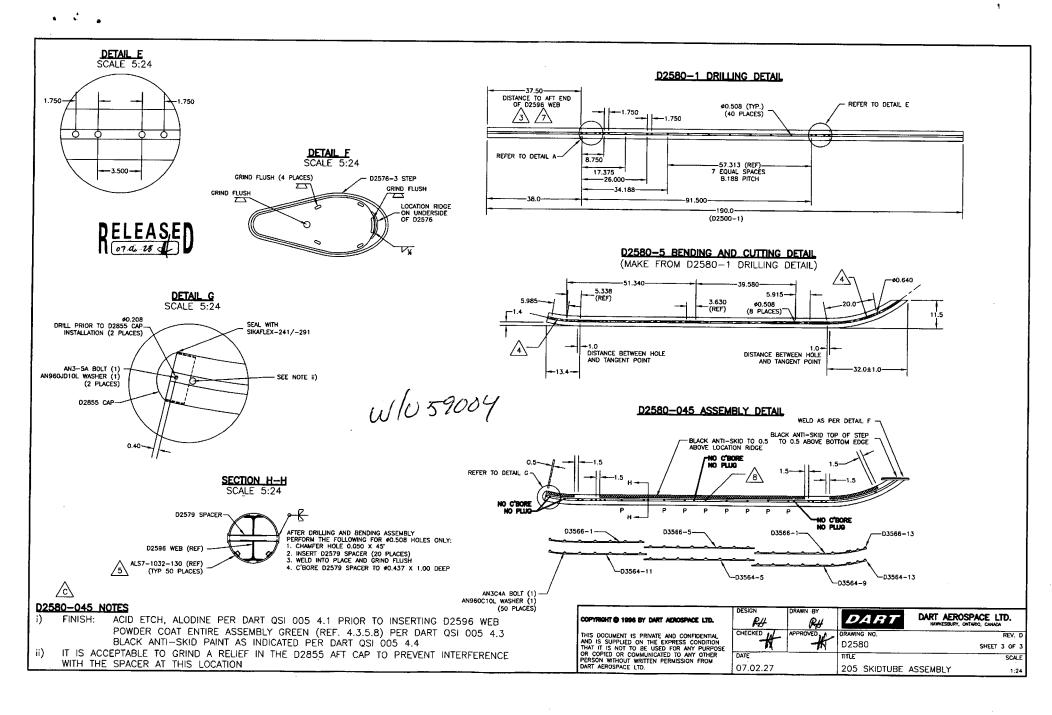
INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:			WO	RK ORDER CHANG	GES					<u>.</u> :
DATE STEP		PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				Disposition: Q						
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section B					rification	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	ion C C	Chief Eng	QC Inspector
							:			
									:	



W/O:			WORK ORDER CHANGES									
DATE STEP		PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									!			
Part No	:	PAR #:	Fault Cate	gory:	_ NCR:	Yes N	lo DQ	\	Date:			
			Disposition: Q									
NCR:			·	ER NON-CONFORM								
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description			on B		ation	Approval Chief Eng	Approval QC Inspector		
			Chief Eng	Chief Eng		Date	Jecti		Officer Ling	QO IIISPECIOI		
									:			
<i>y</i>												



W/O:		WORK ORDER CHANGES									
DATE	STEP				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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			,						÷		
Part No	•	PAR #:	Fault Category: NCR: Yes No DQA: Date: _								
			Dispositio	QA: N/C C	QA: N/C Closed: Date: _						
NCR:		V	WORK ORD	ER NON-CONFORMA	NCE (NCF	₹)			48-4		
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verificat		Approval	Approval		
DAIL SIL	J.L.		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	on C	Chief Eng	QC Inspector		
	-										
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-											
									,		

NO. 232

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Baclay Elliott	
Job number: 59P05	
Part number: <u>D205</u> -634-041	
Description: 805 skid tube	
Welding Process: Tig[Mig[]	
Base materiel: Aluminian	
Current: AC[/] DC[]	

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[fail[] pass[fail[]
UNACCEPTABLE	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[/] fail[]
Qualifier las Duns. Welder Borelow Elle or	Date of Test Coupon 10.06.01 Date of Test Coupon 10.06.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld